Date:

Thursday, 8/24/2006 11:11:21 AM

User:

Kim Johnston

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 28327

Estimate Number

: 10173

P.O. Number

: NIA

: 8/24/2006 This Issue Prsht Rev.

First Issue

MIA : 28244 **Previous Run**

Written By

Checked & Approved By

Comment

: Est D 05.01(3 Material change on Step 2 KJ/JLM

Type : MACHINED PARTS

S.O. No. : NA

Drawing Name

: BUSHING

Part Number

: D2537 . D2537 REV A1

Drawing Number Project Number

: N/A

Drawing Revision

: A1 : NIA

Material **Due Date**

: 9/30/2006

Qty:

20 Um:

Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304R500

0.500" 304 SS roundbar

Comment: Qty.:

0.1203 f(s)/Unit Total: 2.4066 f(s)

Material: AISI 304/316 Round Bar Ø0.500"(M304R.500)

Batch: 101926

06108/26

DO

20

2.0

HARDINGE

HARDINGE CNC LATHE SMALL

Comment: HARDINGE CNC LATHE SMALL

1-Machine as per Folio FA273

2-Deburr and Tumble

3.0

QC2



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

SECOND CHECK

06108126

06108126

QC8

Comment: SECOND CHECK

5.0

PACKAGING

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST49

Al objects

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|--|--|--|--|--|
| DATE | STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector | | | | | |
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| NCR: | | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | |
|------|------|-------------------|----------------------------------|--------------------------------|----------------|--------------|-------------------------------|--------------------------|--|--|--|--|
| | | Description of NC | | Corrective Action Section B | | Verification | Approval Design Mgr | A | | | | |
| DATE | STEP | Section A | Initial Design Mgr | Action Description Design Mgr | Sign & Date | Section C | | Approval QC Inspector | | | | |
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| Part No: | PAR #: | Fault Category: | NCR: | Yes No | DQA: | Date: <u>06/08/</u> 88 |
|----------------------------------|--------|-----------------|------|-----------|--------|------------------------|
| NOTE: Date & initial all entries | | | | QA: N/C C | losed: | Date: |

Date:

Thursday, 8/24/2006 11:11:21 AM

IJser:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 28327

Part Number: D2537

Job Number:

Seq. #:

Machine Or Operation:

Description:

6.0

DC

DOCUMENT CONTROL





Comment: DOCUMENT CONTROL Inspection Level 21



Job Completion



C406108178

Dart Aerospace Ltd

| | WORK ORDER CHANGES | | | | | | | | | | | |
|------|--------------------|----|------|-------|-----------------------------------|---|--|--|--|--|--|--|
| STEP | PROCEDURE CHANGE | Ву | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector | | | | | | |
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| | STEP | | | | STEP PROCEDURE CHANGE By Date Qty | STEP PROCEDURE CHANGE By Date Qty Approval Mfg / Design Mgr | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | | | | |
|------|------|----------------------------------|-----------------------|--------------------------------|----------------|--------------|------------------------|--------------------------|--|--|--|--|
| | | Description of NC | | Corrective Action Section B | | Verification | Approval | | | | | |
| DATE | STEP | Section A | Initial Design Mgr | Action Description Design Mgr | Sign & Date | Section C | Approval Design Mgr | Approval QC Inspector | | | | |
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| Part No: | PAR #: | Fault Category: | NCR: | Yes | No | DQA: | Date: |
|----------------------------------|--------|-----------------|------|-------|-------|--------|-------|
| NOTE: Date & initial all entries | | | | QA: N | 1/C C | losed: | Date: |

| DART AEROSPACE LTD | Work Order: | 28321 |
|-------------------------------|--------------|-------------|
| Description: Bushing | Part Number: | D2537 |
| Inspection Dwg: D2537 Rev: A1 | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|----------------------|---------------|---------------------|--------|--------|----------------------|----------|
| 1.250 | +/-0.010 | 1.255 | | | | |
| 0.316 | +0.005/-0.000 | 0.319 | | | | |
| Ø0.438 | +0.005/-0.000 | 0-441 | / | | | |
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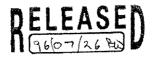
| Measured by: | 5.6 | Audited by: | J.F. | Prototype Approval: | N/A |
|--------------|----------|-------------|----------|---------------------|-----|
| Date: | 06108126 | Date: | 06/08/2/ | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|--------------|------------|--------------|
| A | 03.11.11 | New Issue | KJ/RF | -1 |
| В | 05.02.17 | Added Ø0.438 | KJ/JLM | <i>Shill</i> |

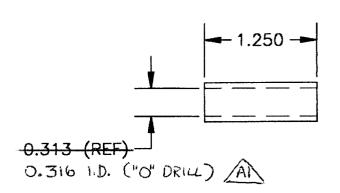




| DESIGN B WILLIAMS | DRAWN BY B WILLIAMS | DART AEROSPACE MICTORIA INTERNATIONAL AIRPORT. | | |
|-------------------|------------------------|--|-------|--------|
| CHECKED | APPROVED | DRAWING NO. | | REV. A |
| m.m. | BU | D2537 | SHEET | |
| DATE | | TILE | | SCALE |
| 96:05:15 | 1 | BUSHING | | 1:1 |
| A) 02.0 | 8.30 M a | 0,316 WAS 0,313 | | |







SHOP COPY RETURN TO

ENGINEERING

MATERIAL: 304/316 SS 7/16 OD 0.063 WALL UNCONTROLLED CORY OR 0.065 WALL

WE 44.09.05 BIECT TO AMENDMENT

WITHOUT NOTICE.